



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9669 9569	34/44/55 ✓
2	Machined By		V.T.L. n/c Shop	Drg No. 18381 ✓
3	Pallet Die No.		10457 (10.0) mm ✓	Reo 2.00 ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	530mm. Step 00 2 491 mm	Step length 11.4 ✓
6	Inside Diameter	Drg. No.	420.12 mm ✓	
7	Width of Pellet Die	Drg. No.	158 mm ✓	
8	Grooves as per Drawing	Drg. No.	11.8 x 8 x 3 mm 11.8 x 8 x 3 mm (A)	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 mm ✓	Tapping No. of Holes = 8 ✓
13	Tapping Hole Diameter		H202 Check by H20 Bolt ✓	Both Side ✓
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.4 mm Tapping Depth 16.8 mm ✓	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 31/5/23	
1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	OK	
4	Defective Holes (If Any)		No	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Row 2 8
2	External Relief Dia	10.3 mm / 10.5 mm	10.3 mm All Lines	10.5 mm All Lines
3	External Relief Depth	✓	9 mm	11 mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		31 5 23	
Inspected By (Sign) & Date			Ravi 31/5/23	

Reviewed by (Engineer-CNC)

Manager-QA